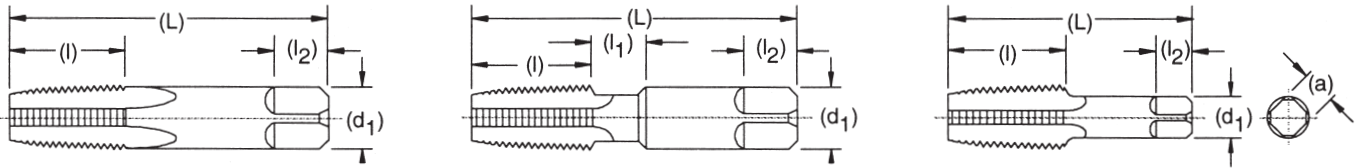


STANDARD PIPE TAP DIMENSIONS STRAIGHT AND TAPER, GROUND THREAD (Ref. USCTI Table 311)



General Dimensions

Dimensions - Inches						
Nominal Size Inches	Length Overall L	Length of Thread l	Length of Square l ₂	Dia. of Shank d ₁	Size of Square a	Length Optional Neck l ₁
1/16	2.13	.69	.38	.3125	.234	.375
* 1/8	2.13	.75	.38	.3125	.234	...
1/8	2.13	.75	.38	.4375	.328	.375
1/4	2.44	1.06	.44	.5625	.421	.375
3/8	2.56	1.06	.50	.7000	.531	.375
1/2	3.13	1.38	.63	.6875	.515	...
3/4	3.25	1.38	.69	.9063	.679	...
1"	3.75	1.75	.81	1.1250	.843	...
1-1/4	4.00	1.75	.94	1.3125	.984	...
1-1/2	4.25	1.75	1.00	1.5000	1.125	...
2"	4.50	1.75	1.13	1.8750	1.406	...
2-1/2	5.50	2.56	1.25	2.2500	1.687	...
3"	6.00	2.63	1.38	2.6250	1.968	...
3-1/2	6.50	2.69	1.50	2.8125	2.108	...
4"	6.75	2.75	1.56	3.0000	2.250	...

* Small shank

Tolerances

Element	Range	Direction	Tolerance
Length Overall - L	1/16 to 3/4 inc.	Plus or Minus	.031
	1" to 4" inc.	Plus or Minus	.063
Length of Thread - l	1/16 to 3/4 inc.	Plus or Minus	.063
	1" to 1-1/4 inc.	Plus or Minus	.094
	1-1/2 to 4"	Plus or Minus	.125
Length of Square - l ₂	1/16 to 3/4 inc.	Plus or Minus	.031
	1" to 4" inc.	Plus or Minus	.063
Diameter of Shank - d ₁	1/16 to 1/8	Minus	.0015
	1/4 to 1" inc.	Minus	.0020
	1-1/4 to 4" inc.	Minus	.0030
Size of Square - a	1/16 to 1/8	Minus	.004
	1/4 to 3/4 inc.	Minus	.006
	1" to 4" inc.	Minus	.008

NOTE: For thread limits and tolerances see USCTI Tables 335, 335A and 338. For eccentricity tolerances of taps see Table 317.